

Work Order ID 101833-2

May-13-13 1:15:14 PM

101833

Page 1

Item ID: D3531-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-05-14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3531

B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Transfer drill holes and assemble as per dwg D3531

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

1-40

M123480

12/06/21

2x M-f 13/06/26

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Page 2

Item ID: D3531-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 5/13/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
QC:		Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00


130

QC

Memo

0.00

Quality Control

2 ϕ 13-6-26. 

140 Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

PPP103798

2x

SP
13-6-27

150 QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

13/6/27 

W15-0627

Picklist Print

May-13-13 1:15:14 PM

Page 1

Work Order ID: 101833
Parent Item: D3531-041
Parent Item Name: Bracket Assembly

Start Date: 5/13/13
Start Qty: 4.00

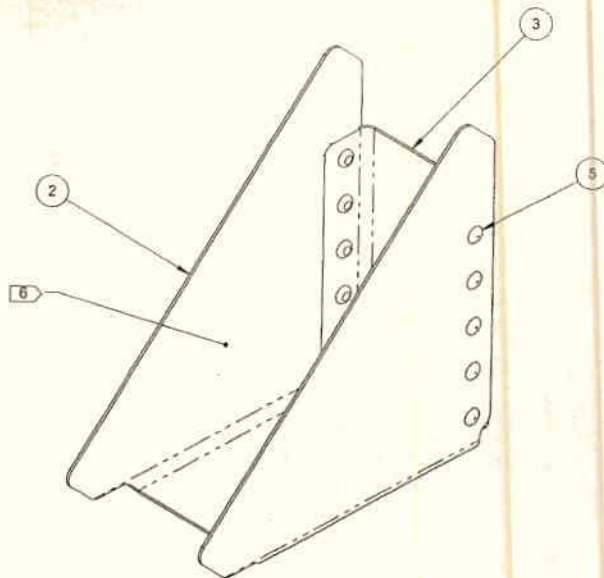
Required Date: 5/24/13
Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD REV.B DD VERF:JLM
IPP REV:B 12.10.24 PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 Bracket		Manufactured	No			100	Each	13.0000	1	4		5/13/06/21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		13							
				86071		2							
				96115		11							
D3531-3 Bracket Front Plate		Manufactured	No			100	Each	3.0000	1	4		5/13/06/21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		3							
				83014		1							
				95123		2							
MS20426AD4-4 Rivet		Purchased	No			100	Each	6,407.0000	2	8		5/13/06/21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		347							
				121090		347							
				ST506		6060							
				125445		6060							
MS20470AD4-4 Rivet, Universal Head		Purchased	No			100	Each	5,768.0000	10	40		5/13/06/21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		1							
				121652		1							
				ST336		391							
				116188		68							
				118614		135							
				122027		188							
				ST506		5376							
				125268		5376							

20

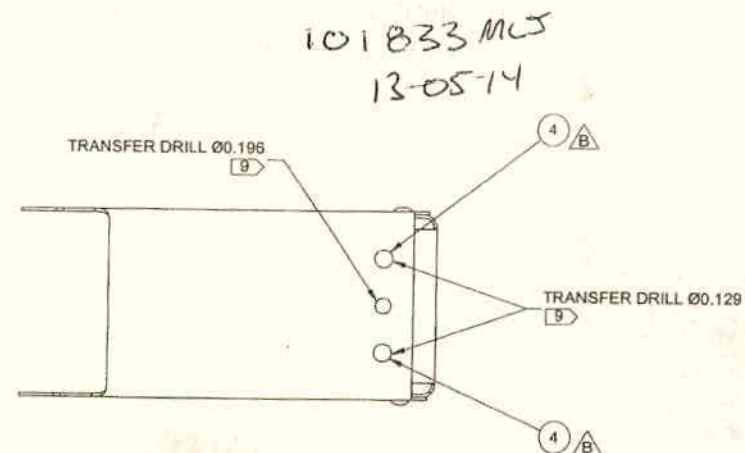
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

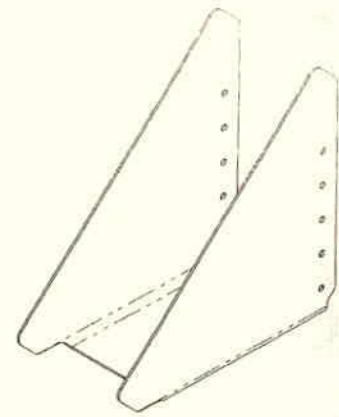
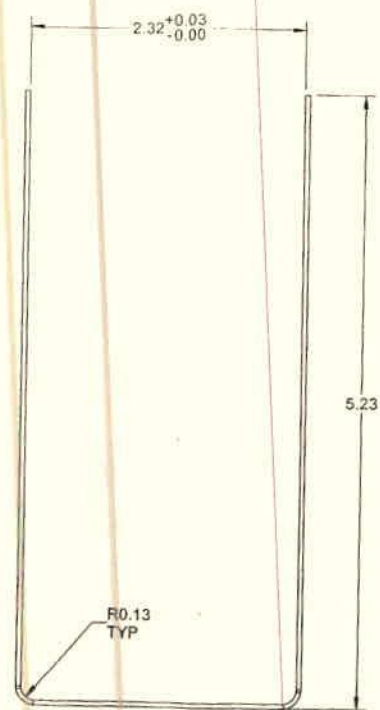


**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/10/13
PER ECU 12-661

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3, ADD CSK ZN C5-3, CORRECT BEND LINE DIM. ZN C4-3, UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.08.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.08.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3531 BRACKET ASSEMBLY REV. B SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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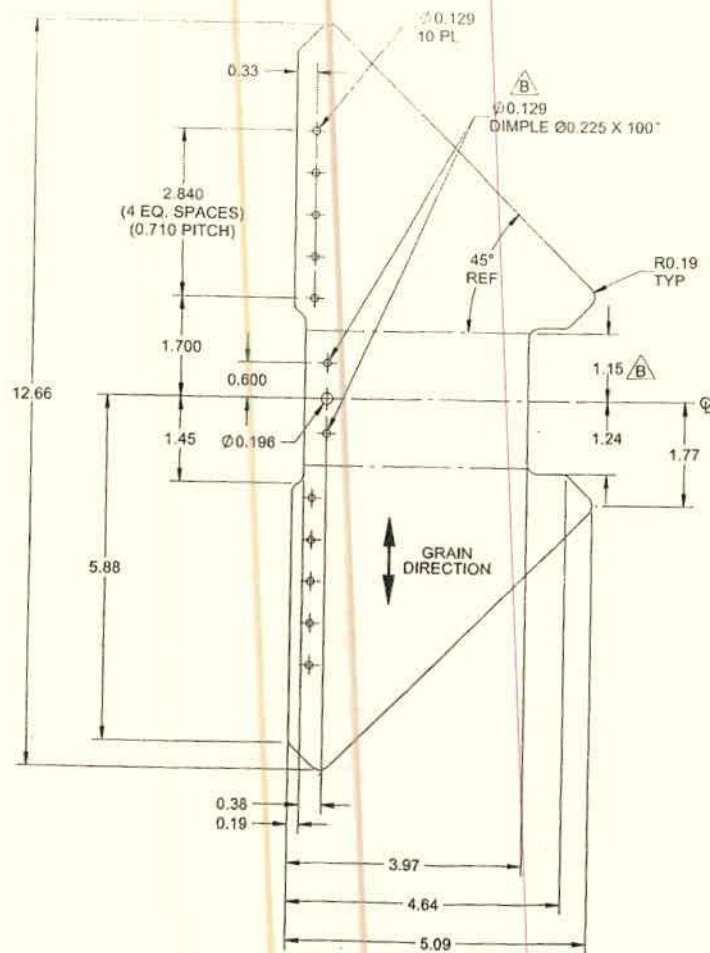
D3531-1 BRACKET

RELEASED
12/19/15 UP

- NOTES:**
- 1) MATERIAL: MADE FROM D3531-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

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APPROVED	140	TITLE	SCALE
DE APPR.	14	BRACKET ASSEMBLY	NTS
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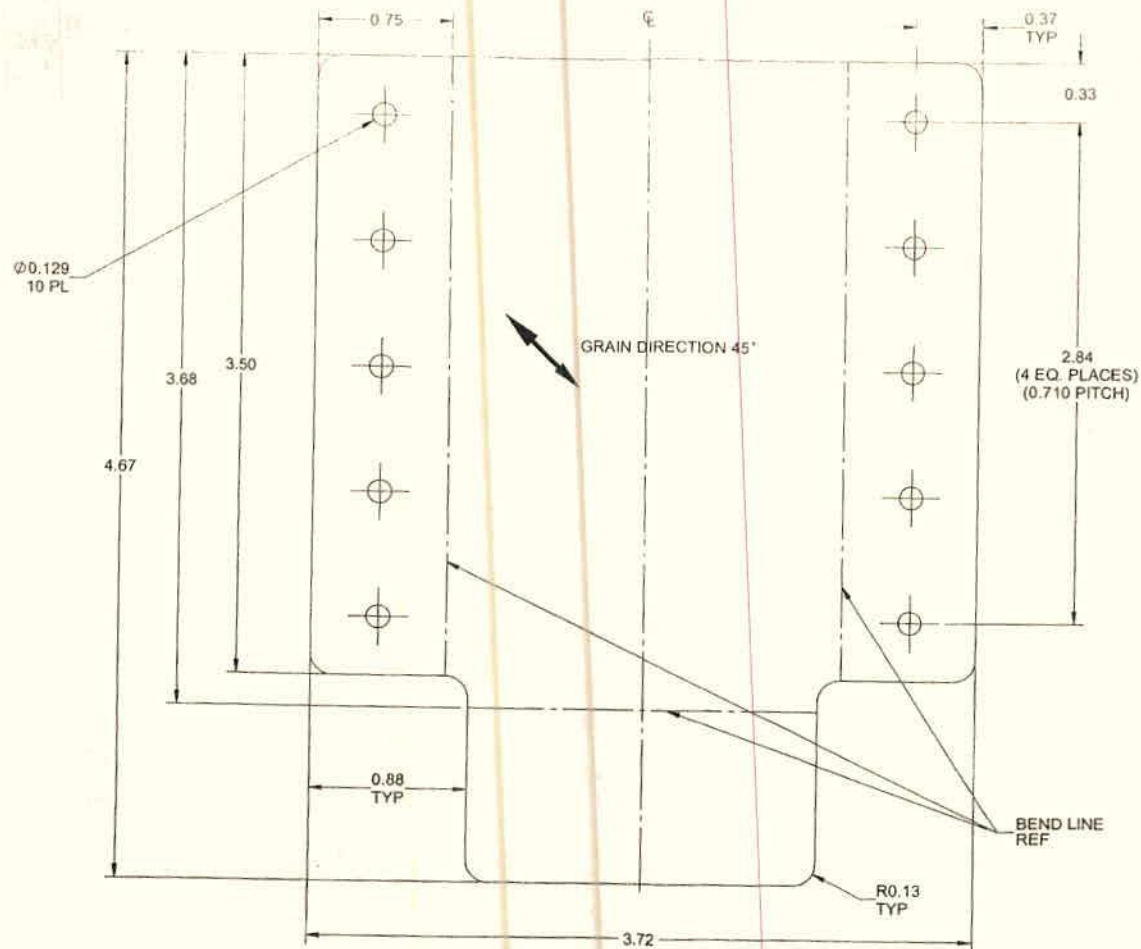
D3531-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

RELEASED
12/14/09

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DE APPR.	JE	BRACKET ASSEMBLY	NTS
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D3531-3F FLAT PATTERN

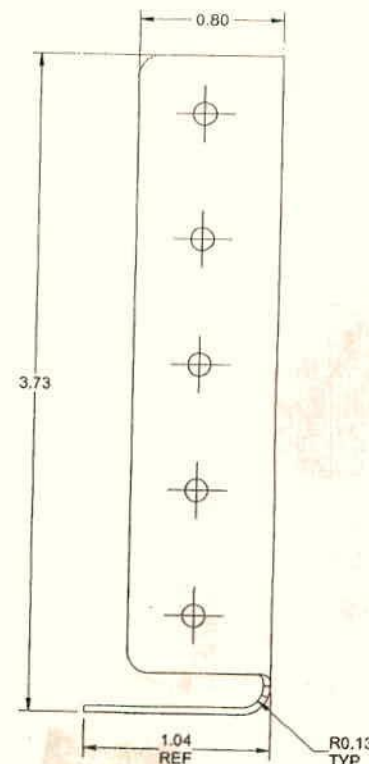
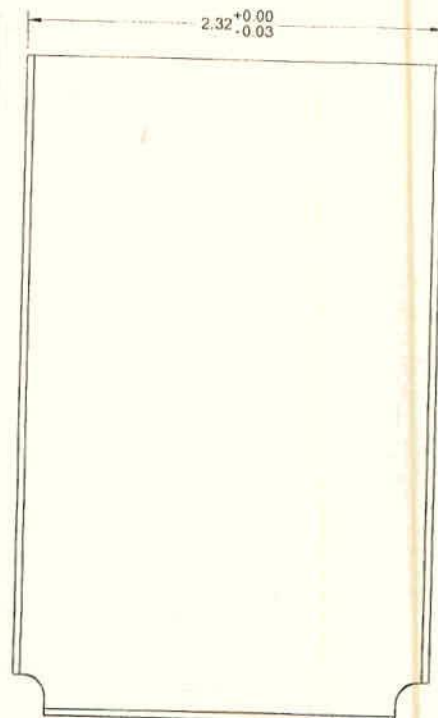
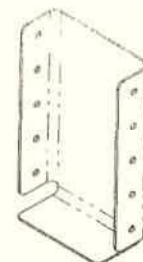
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

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MFG. APPR.	AS	D3531	SHEET 5 OF 5
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RELEASED
12/12/13

101833



RELEASED
12/10/13

D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: MADE FROM D3531-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

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